

BOR/a[®]

ACTIVE PERFORMANCE SOUND™



INSTALLATION GUIDE

Ford Mustang Mach-E

BEFORE YOU BEGIN

Confirm you have all the parts necessary for this installation by matching the items in the box with the parts list in this manual.

These instructions have been written to help you with the installation of your Borla Performance Active Performance Sound™ system. Please read this manual completely before beginning your installation.

Borla Performance Industries recommends a professional aftermarket parts installer perform the installation of this system. If you choose to install our Borla Performance Active Performance Sound™ system yourself, ensure that you follow all appropriate safety precautions, including eye protection. By performing your own installation, you indicate that you have read and agree with the following terms:

It is the responsibility of the purchaser to follow all installation instruction guidelines and safety procedures as described and recommended in this manual. Borla Performance Industries assumes no responsibility for damages occurring from misuse, abuse, improper installation, improper operation, lack of responsible care, or all previously stated reasons resulting from incompatibility with other manufacturer's products and/or systems.

Included in this manual is a link to your warranty and a registration form. Please read the warranty carefully before you begin any work on your vehicle. If you should have any questions regarding our warranty policy, installation, or any other matter pertaining to your new Borla Performance Active Performance Sound™ system, please give us a call toll-free at 1-877- GO BORLA. Live support is available from 7:30am - 4:00pm PST, Monday through Friday.

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TOOLS YOU'LL NEED



Ratchet with 10mm Socket



Wire Snake (or similar)



Diagonal Cutters



13mm & 15mm Wrenches



1/2 inch Drill Bit



Pick Tool



Plastic Panel/Trim Removal Tool



#0 Phillips Screwdriver



Drill



Drill Bit Holder with #2 Phillips Bit

PARTS LIST

SPEAKER ENCLOSURE & BRACKETS

BOR-FME21



DSP/AMPLIFIER UNIT

DSP BOR-DSP1

Amplifier BOR-350x2

Mount Bracket BOR-FME21B



BORLA SOUND CONTROLLER

BOR-CON2



SPEAKER WIRING HARNESS

BOR-FMESPK-HAR



POWER WIRING HARNESS

BOR-PWR-HAR



DATA WIRING HARNESS

BOR-DATA-HAR



GROUND CABLE

BOR-FMEGND-HAR



BORLA SPEAKER GRILLS

BOR-FME21G



ALLEN KEY

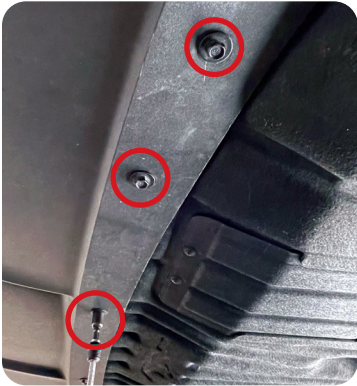


ASSORTED HARDWARE



1 INSTALL THE SPEAKER ENCLOSURE

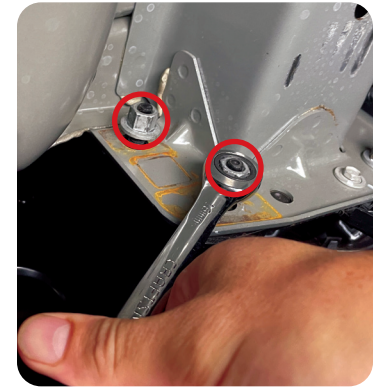
STEP 1: Remove the under body panel. This can be done by removing the eighteen 10mm bolts holding the panel in place. There are six bolts to remove from the front of the panel and twelve bolts to remove from the rear, closest to the bumper, of the panel. With the bolts removed, drop the panel and slide it out from under the vehicle.



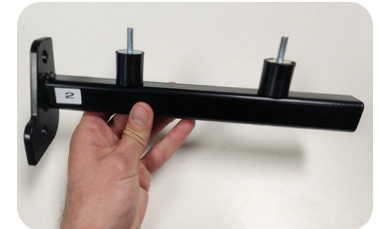
STEP 2: Next, remove the factory alert speaker. Remove the two 10mm bolts holding the factory alert speaker to the under body of the vehicle. Unplug the speaker and set aside.



STEP 3: Next, remove the inside, factory bumper nuts. There will be two 15mm nuts on each side of the factory bumper in the cavity that was exposed earlier. Remove all four nuts to prepare to mount the enclosure brackets.



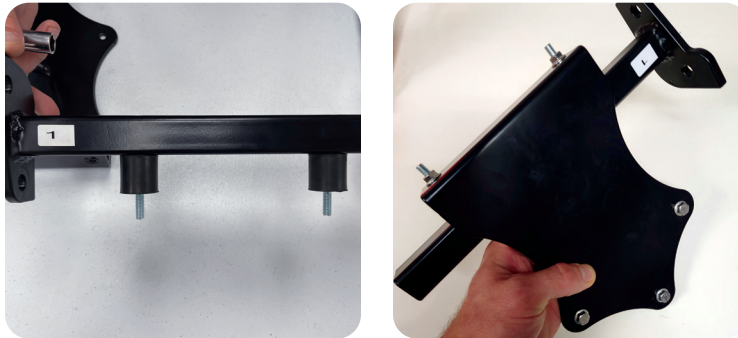
STEP 4: With the four 15mm nuts removed, move on to assembling the brackets that will hold the enclosure to the vehicle. Begin by attaching two of the rubber isolators to bracket "2" using two 10mm nuts.



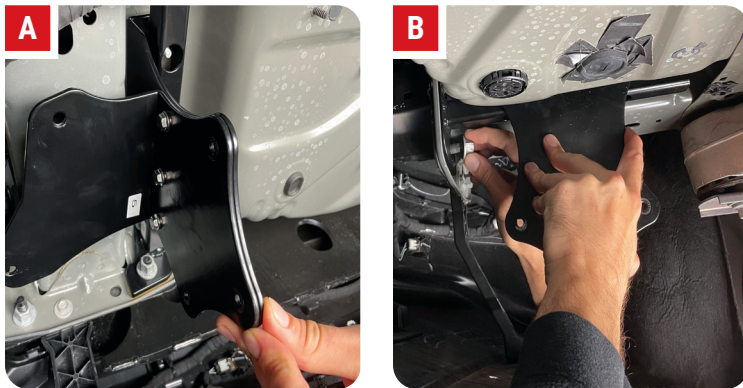
STEP 5: Next, assemble brackets "4" and "5" together using three 10mm nuts and the shorter bolts. Then, attach bracket "2" with the rubber isolators to the bracket "4" and "5" assembly using two of the provided 10mm nuts.



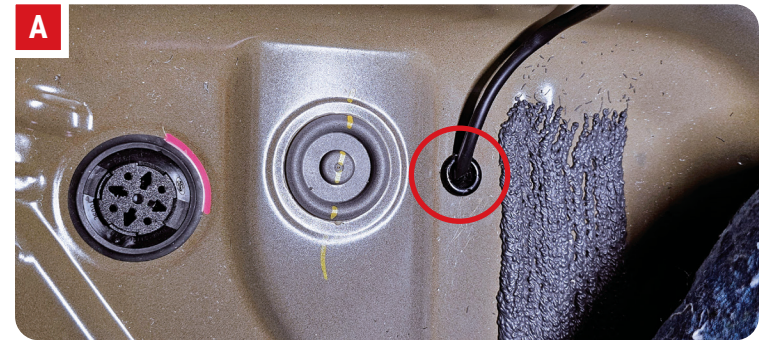
STEP 6: With the passenger side bracket assembled, begin assembling the driver side bracket by attaching the remaining two rubber isolators to bracket "1" using two of the 10mm nuts. Next, attach bracket "1" with the rubber isolators to bracket "3" using two 10mm nuts.



STEP 7: Install the two bracket assemblies onto the vehicle. Bracket "2/4/5" installs on the passenger side of the vehicle. Use the original 15mm bumper bolts that were previously removed to secure the assembly into place (A). Bracket assembly "1/3" installs on the driver side of the vehicle. Use the original 15mm bumper bolts that were previously removed to mount the bracket into place (B).



STEP 8: With the brackets installed, next move on to routing the BOR-FMESP-K-HAR into the area exposed by removing the under body panel. Begin from the inside of the vehicle and pull back the carpet in the trunk to expose the rubber grommet and vent in the drivers side rear corner. Drill a 5/8" hole from the inside of the vehicle and then route the 2 pin connector side of the harness in from the underside of the vehicle leaving a few inches to connect to the enclosure. Seat the grommet as shown in (A).



STEP 9: Next, move on to mounting the Speaker Enclosure (BOR-FME21) to the previously installed brackets. Orient the Speaker Enclosure with the speakers facing down and to the rear of the vehicle. Using the remaining six 10mm bolts, install three per side to hold the Enclosure securely to the brackets. Be sure to install a rubber washer on each side of each bracket on each of the mounting bolts. See the images below for reference.



STEP 10: Next, re-install the Factory Alert Speaker to bracket "2/4/5" on the passenger side using two provided 10mm nuts and the factory 10mm bolts that previously secured the Factory Alert Speaker to the underside of the vehicle. Reconnect the factory harness to the speaker. Also, be sure to connect the Speaker Wiring Harness connector into the back of the Enclosure.



STEP11: Finally, remove two #2 phillips screws from the under body panel that was removed from the underside of the vehicle. Install the two Borla Speaker Grills (BOR-FME21G) and secure them to the panel using the previously removed phillips screws.



2 ROUTE THE SPEAKER WIRING

STEP 1: Route the Speaker Wiring Harness to the front of the vehicle following the factory wiring along the driver side door sill. Begin by routing the harness from the grommet along the driver side of the vehicle (A). Next, you will need to remove the door sill panels in the driver side front and rear. Using a panel removal tool or similar, pop up the panel along the driver side rear door (B) and pull away from the vehicle and continue routing the Harness towards the front (C).



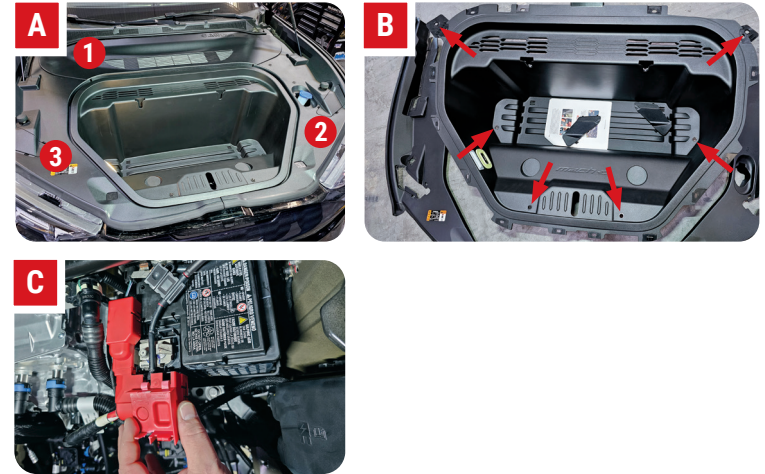
STEP 2: Next, move to the driver side front of the vehicle to remove a few panels to continue the Speaker Wiring Harness routing. Using a panel removal tool or similar, remove the panel on the side of the dash (A). Then, remove the small trim panel below the A pillar (B). Next, you will remove the driver side door sill panel.



STEP 3: To remove the driver door sill panel you will need to remove the frunk release handle. Make sure to pull the release handle twice to have access to the frunk area for a future step. Next, using a pick tool or similar, slide it in over the top of the frunk release handle and pry up (A). You should feel a little click when the handle retention clip has been released. Carefully pull the handle off being sure not to lose track of the small retention clip (B). With the handle off, remove the door sill panel and set aside (C). With the panels removed, route the Harness end to just above the driver side kick panel.



STEP 1A: On some 2023 Mach-E vehicles, accessing the battery and firewall grommet requires a slightly different procedure. Using a panel removal tool, remove the panels shown in (A) starting with the panel closest to the windshield (1), then the drivers side (2), then the passengers side (3). With the panels removed, locate the 6 T25 screws in (B) and remove to allow removal of the main Frunk panel. Due to the new refreshed design, the fuse holder will sit on top of the battery as shown in (C).



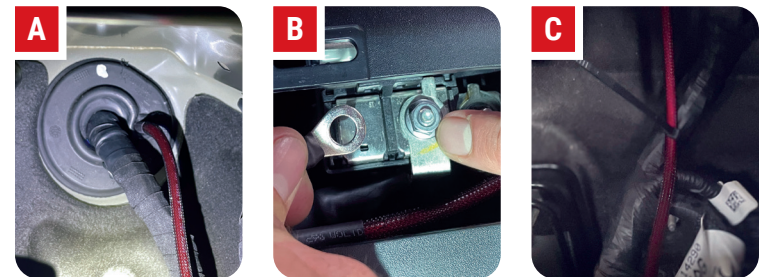
3 CONNECT THE DSP/AMPLIFIER WIRING HARNESSES

! Later 2023 Mach-E models may require an alternate procedure (described in STEP 1A) for battery access.

STEP 1: With the Speaker Enclosure installed and the Speaker Wiring Harness routed to the front, you can move on to installing and routing the remainder of the harnesses for the DSP/Amplifier. Begin in the frunk area that was opened previously. Using a panel removal tool or similar, remove the large and small access panels covering the battery. Be careful as the clips can easily break.



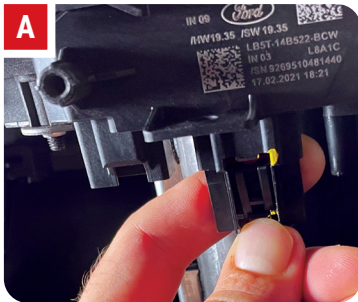
STEP 2: With the panels removed, locate the grommet on the firewall behind the battery. There will be a small access point on the right side of the grommet. Using a pair of diagonal cutters or similar, cut the end off of the access point and route the ferrule end of the Power Wiring Harness (BOR-PWR-HAR) through the access point into the vehicle (A). Route the other end of the Harness to the positive battery terminal. Remove the 10mm nut and connect the terminal of the Power Wiring Harness and re-install the previously removed 10mm nut (B). Using supplied zip ties, secure the Power Wiring Harness to existing factory wiring (C) behind the battery being sure to put enough length into the vehicle to reach the Amplifier. DO NOT INSTALL THE FUSE AT THIS POINT.



STEP 3: Next, move on to installing the Data Wiring Harness (BOR-DATA-HAR). You will need to remove the bottom of the steering wheel cover. There will be two 7mm bolts to remove. Once removed, the plastic can be pulled down to remove the cover.



STEP 4: With the bottom steering wheel cover removed, locate the 8 pin factory connector on the bottom side of the steering wheel and disconnect it (A). Install the t-harness end of the Data Wiring Harness in-line with the factory connector (B).



STEP 5: Route the Data Wiring Harness along factory wiring to the driver side kick panel area (A). Using the supplied zip ties, secure the Harness to the factory wiring (B).

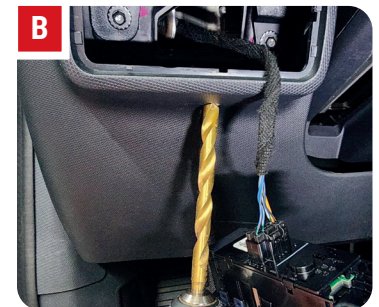


STEP 6: Take the DSP/Amplifier Unit and connect the supplied Ground Cable (BOR-FMEGND-HAR) to the spot marked "Ground" (A) and tighten with the supplied allen key. Next, connect the single, small ferrule crimped wire and connect it to the spot marked "remote" on the Amplifier and tighten with the supplied allen key. Then, take the previously-ran Power Wiring Harness and connect it to the spot marked "+12V" and tighten with the supplied allen key. Finally, connect the 12 pin black connector from the Data Wiring Harness to the amplifier as shown in (B).

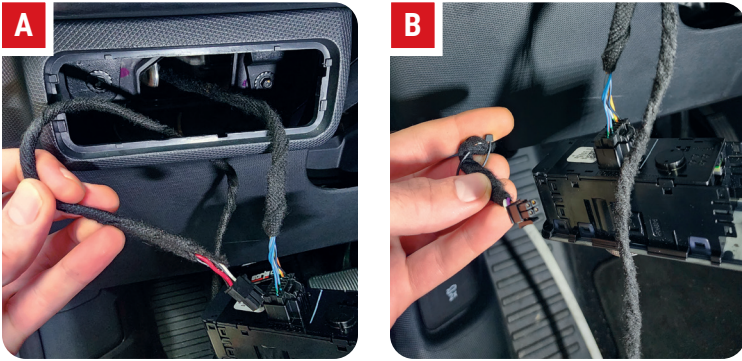


4 MOUNT THE BORLA SOUND CONTROLLER

STEP 1: Next, move on to installing the Borla Sound Controller (BOR-CON2). Use a panel removal tool or similar to remove the factory light control panel to the left of the steering column (A). Center the Borla Sound Controller below the light control panel opening and mark the spot where the Harness comes out of the Controller. Then, using a 1/2 inch bit, drill a hole in the spot marked (B).



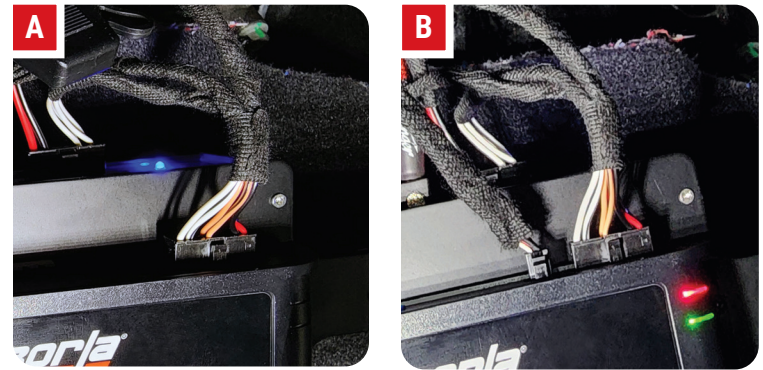
STEP 2: Feed the 4 pin connector end through the 1/2 inch hole and pull through (A). Then, using a wire snake or similar, route the 4 pin connector end down to the driver side kick panel area (B).



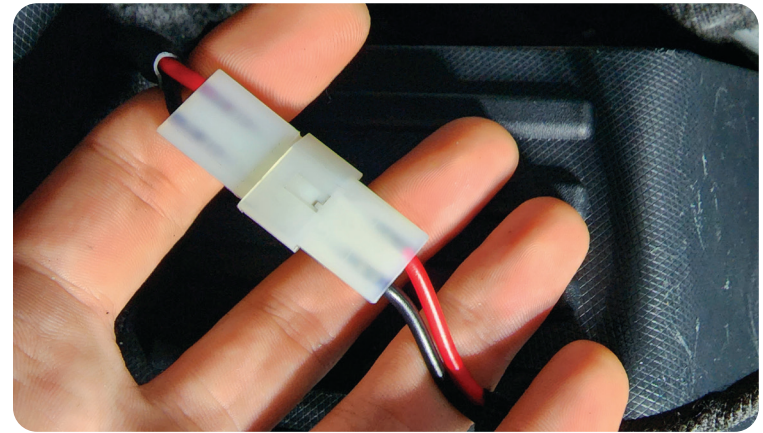
STEP 3: Next, using a small screwdriver, position the Controller in place and mount it to the dash using the two provided screws.



STEP 4: With the Harness routed and the Controller mounted in place, connect the 16 pin connector that was routed to the driver side kick panel area in a previous step to the DSP (A). Then, connect the 4 pin black connector from the Controller to the DSP (B).

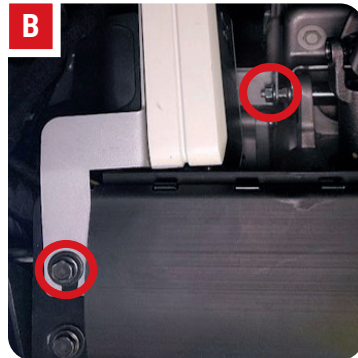


STEP 5: Finally, connect the 2 pin white connector from the Data Wiring Harness to the previously ran Speaker Wiring Harness in the driver side kick panel area.



5 INSTALL THE DSP/AMPLIFIER UNIT

STEP 1: With the Harnesses now connected to the DSP/Amplifier Unit, proceed with mounting the Unit in place. Locate and remove one 10mm bolt on the under dash closer to the firewall, just beside the OBDII connector (A). Locate and hang the DSP/Amplifier Unit on the exposed bolt high in the dash, shown in the upper red circle in (B). With the mounting bracket seated on the upper bolt, use the supplied 13mm nut to tighten the Unit to the to the upper bolt (B). Then align the bracket over the hole from the 10mm bolt you removed and secure it by replacing the bolt (A).



STEP 2: With the DSP/Amplifier Unit now mounted in place, locate and remove a 10mm bolt from the factory ground point above the driver side kick panel (A). Install the terminal end of the Ground Cable on to the factory ground point being sure to not leave off the factory ground wire (B). Using the supplied zip ties, secure any installed wires up and out of the way.



STEP 3: To complete the installation, install the supplied fuse into the fuse holder on P-BOR-PWR-HAR that was previously installed near the battery. Proceed with testing the system for functionality and putting the vehicle back together.



6 POWER UP YOUR BORLA SOUND SYSTEM

Once your hardware installation is complete, you can begin enjoying your Borla Active Performance Sound™ right away. With the vehicle on, simply turn the right-side knob on your Borla Sound Controller clockwise to power up the system and adjust volume. The left-side knob marked "Presets" is where you select the sound you want to use. We've already activated four sounds for you to choose from, listed below with their corresponding preset knob number:

PRESET #	VEHICLE EMULATION	SOUND
1	Ford Mustang 5.0L GT	ATAK®
2	Ford Mustang GT500	ATAK®
3	Chevrolet Corvette C8	ATAK®
4	Dodge Charger SRT 392	ATAK®

You can browse, preview and select other sounds from the extensive Borla library to replace these presets, via the Borla app (coming early 2024). By registering for your warranty, you'll automatically receive update notices on the app's release. If you haven't registered already, just scan the code below or [tap here](#).





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